

Date: Thursday, 4/12/2007 8:45:13 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 31722	
Estimate Number : 10534	
P.O. Number : <u>N/A</u>	Part Number : D2574
This Issue : 4/12/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 31718	Material : <u>N/A</u>
Written By : _____	Due Date : 4/30/2007 Qty: 16 Um: Each
Checked & Approved By : <u>07.04.12</u>	
Comment : Est Rev: I As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	D6101005	7075-T7351 8.25X5.0X2.5
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: _____

B25332 (16)
 En 07/05/06

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 331722 Double check by: SD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

MS/En 07/05/15 (X16)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

MS/En 07/05/15 (X16)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS/En 07/05/15 (X16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/05/18

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:45:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 31722

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.05.15

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

esl

07-05-16

(16)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

esl

07-05-17

(16)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Mid

07/05/17

(16X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5433

07/05/17

(16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/18

(16)

Job Completion



U 07.05.18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31722
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440	.440	0.440		
B	1.745	1.755		1.748	1.748	1.750	1.750		
C	3.495	3.505		3.500	3.501	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.500	.500	.500	0.500		
G	0.257	0.262	DT8683	.258	.258	.258	0.258		
H	0.375	0.380	DT8684	.378	.378	.378	0.378		
I	0.490	0.510		.500	.501	.501	0.501		
J	1.174	1.184		1.174	1.174	1.174	1.174		
K	0.558	0.578		.560	.561	.561	0.561		
L	1.174	1.184		1.174	1.174	1.174	1.174		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.500	2.501	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	0.125		
Q	0.115	0.135		.128	.128	.128	0.128		
R	0.240	0.260		.250	.250	.250	0.250		
S	0.115	0.135		.125	.125	.125	0.125		
T	0.178	0.198		.188	.188	.188	0.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		.240	.242	.240	0.240		
W	0.115	0.135		.125	.125	.125	0.125		
X	0.307	0.312		.310	.310	.310	0.310		
Y	0.760	0.765		.762	.762	.762	0.762		
Z	0.352	0.372		.362	.362	.362	0.362		
AA	0.470	0.530		.501	.502	.500	0.500		
AB	0.615	0.635		.625	.625	.625	0.625		
AC	0.053	0.073		.062	.063	.063	0.063		
AD	0.240	0.260		.250	.250	.250	0.250		
AE	1.500	1.520		1.510	1.512	1.512	1.512		
AF	0.115	0.135		.125	.125	.125	0.125		
AG	0.240	0.280		.250	.250	.250	0.250		
AH	0.240	0.260		.250	.250	.250	0.250		
AI	2.000	2.020		2.000	2.001	2.001	2.001		
AJ	0.023	0.043		.032	.032	.032	0.032		
Accept/Reject									

Measured by:	<i>MS</i>
Date:	02/05/09

Audited by:	<i>SA</i>
Date:	07.05.15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31722
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.747	1.749	1.748	1.748		
C	3.495	3.505		3.500	3.499	3.501	3.500		
D	1.745	1.755		1.747	1.749	1.748	1.748		
E	7.990	8.010		8.003	8.004	8.004	8.002		
F	0.490	0.510		0.496	0.494	0.500	0.495		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.500	0.497	0.500		
J	1.174	1.184		1.176	1.175	1.178	1.175		
K	0.558	0.578		0.566	0.565	0.566	0.566		
L	1.174	1.184		1.176	1.175	1.178	1.175		
M	1.365	1.375		1.367	1.367	1.368	1.366		
N	2.495	2.505		2.497	2.497	2.498	2.496		
O	4.119	4.129		4.122	4.122	4.122	4.121		
P	0.115	0.135		0.128	0.128	0.128	0.128		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.254	0.253		
S	0.115	0.135		0.125	0.124	0.124	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.238	0.241	0.238		
W	0.115	0.135		0.129	0.131	0.129	0.131		
X	0.307	0.312		0.310	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.369	0.369	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.628	0.624	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.248	0.246	0.249		
AE	1.500	1.520		1.510	1.510	1.509	1.509		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.247	0.252	0.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EP / MS
Date:	07.05.11

Audited by:	SA
Date:	07.05.11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31722
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.748	1.749	1.750		
C	3.495	3.505		3.500	3.498	3.501	3.500		
D	1.745	1.755		1.749	1.748	1.749	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		0.499	0.496	0.499	0.500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.374	0.377	0.379	0.379		
I	0.490	0.510		0.497	0.496	0.496	0.499		
J	1.174	1.184		1.178	1.176	1.175	1.175		
K	0.558	0.578		0.565	0.565	0.564	0.565		
L	1.174	1.184		1.178	1.176	1.175	1.179		
M	1.365	1.375		1.368	1.365	1.365	1.367		
N	2.495	2.505		2.499	2.497	2.495	2.500		
O	4.119	4.129		4.123	4.123	4.123	4.123		
P	0.115	0.135		0.128	0.127	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.252	0.252	0.252		
S	0.115	0.135		0.126	0.122	0.126	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.240	0.239	0.240		
W	0.115	0.135		0.134	0.135	0.133	0.132		
X	0.307	0.312		0.310	0.311	0.311	0.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.362	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.629	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.249	0.249	0.250		
AE	1.500	1.520		1.510	1.508	1.508	1.509		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.247	0.249	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	ER/MB
Date:	07/05/14

Audited by:	SN
Date:	07.05.15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31722
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

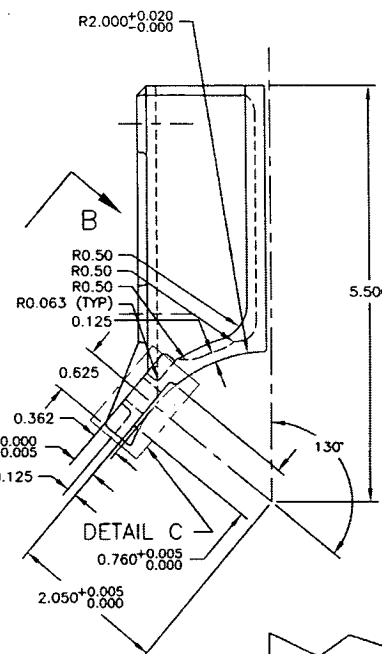
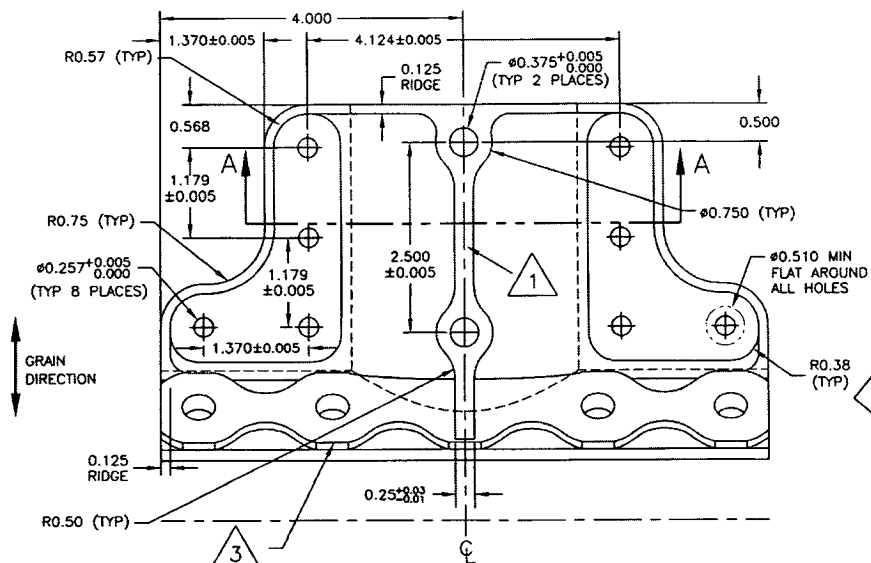
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.499	3.500		
D	1.745	1.755		1.750	1.751	1.749	1.749		
E	7.990	8.010		8.000	8.000	8.004	8.004		
F	0.490	0.510		.500	.499	0.499	0.498		
G	0.257	0.262	DT8683	.258	.258	0.260	0.260		
H	0.375	0.380	DT8684	.376	.376	0.377	0.377		
I	0.490	0.510		.501	.501	0.500	0.499		
J	1.174	1.184		1.179	1.179	1.176	1.178		
K	0.558	0.578		.568	.569	0.562	0.565		
L	1.174	1.184		1.179	1.179	1.176	1.178		
M	1.365	1.375		1.370	1.370	1.368	1.368		
N	2.495	2.505		2.500	2.499	2.498	2.497		
O	4.119	4.129		4.123	4.123	4.120	4.120		
P	0.115	0.135		.132	.132	0.126	0.126		
Q	0.115	0.135		.130	.130	0.135	0.135		
R	0.240	0.260		.250	.250	0.251	0.251		
S	0.115	0.135		.125	.125	0.122	0.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.231	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	0.241	0.238		
W	0.115	0.135		.125	.125	0.135	0.135		
X	0.307	0.312		.312	.312	0.311	0.311		
Y	0.760	0.765		.762	.762	0.765	0.765		
Z	0.352	0.372		.365	.365	0.362	0.362		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		.625	.625	0.625	0.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	0.250	0.251		
AE	1.500	1.520		1.509	1.510	1.510	1.509		
AF	0.115	0.135		.125	.125	0.135	0.135		
AG	0.240	0.280		.260	.260	0.260	0.260		
AH	0.240	0.260		.250	.250	0.248	0.248		
AI	2.000	2.020		2.007	2.005	2.000	2.000		
AJ	0.023	0.043		.032	.032	.032	.032		
Accept/Reject									

Measured by: MS	Audited by: SN
Date: 07/05/14 / 07/05/15	Date: 07.05.15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



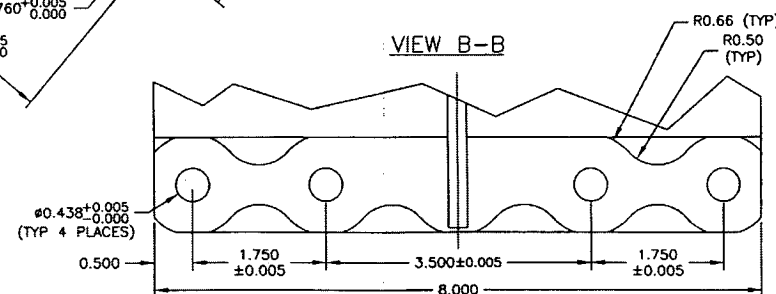
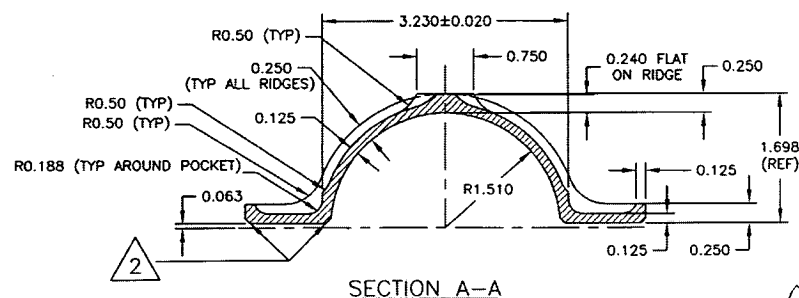
05.12.06 ~~11~~



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED


- | | |
|---|--|
| 1 | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
| 2 | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
| 3 | CHAMFER 0.063 x 45° ALL AROUND |
| 4 | CHAMFER 0.033 x 45° (SEE DETAIL C) |



DETAIL C
SCALE 2:1

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
DRAWN BY PH		
CHECKED	APPROVED	DRAWING NO. D2574
DATE 05.07.13		TITLE INNER AFT SADDLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31722